

IN THE CLAIMS:

Claims 1-36, 67, 68 and 70 were previously canceled. Claims 37, 55 and 56 are currently amended. Claims 38-54, 57-66 and 69 are carried forward, all as follows:

Claims 1-38. (Canceled)

37. (Currently Amended) A method for storing unprepared rolls of material and prepared rolls of material for use in roll changers in a web-fed rotary printing machine including:

providing a stock reception area :

receiving rolls of material for use in said web-fed rotary printing machine in said stock reception area;

providing a depot for receiving ~~selected ones of said~~ rolls of material from said stock reception area;

providing a defined number of roll storage spaces in said depot;

locating selected ones of said roll storage spaces in said depot adjacent said web-fed rotary printing machine;

providing a roll preparation circuit and using said roll preparation circuit for preparing rolls of material for use in said roll changers;

transferring prepared rolls of material from said roll preparation circuit and unprepared rolls of material from said stock reception area to separate ones of said defined storage spaces in said depot;

providing a material flow system for said web-fed rotary printing machine;

providing an implemented logic device for managing said material flow system;

providing said material flow system with production-relevant data for a planned production run of said web-fed rotary printing machine;

providing a depot management system in said depot and having knowledge of properties of said prepared rolls of material and said unprepared rolls of material located in said ones of said defined roll storage spaces in said depot;

determining, in a first partial process of said material flow system, a production-oriented storage strategy for using said rolls of material located in said storage spaces in said depot using said production-relevant data for said planned production run;

checking, in a second partial process of said material flow system, information on said occupancy, in said ones of said defined storage spaces in said depot of said unprepared rolls of material and said prepared rolls of material located in said defined storage spaces;

using said production-oriented storage strategy and said information on said positioning of said unprepared rolls of material and said prepared rolls of material in occupancy in said depot and repositioning said rolls of material in said depot for optimizing delivery of said prepared rolls of material from said depot to said roll changers of said web-fed rotary printing machine during operation of said web-fed rotary printing machine by positioning said prepared rolls of material in said selected ones of said depot roll storage spaces adjacent said web-fed rotary printing machine and for optimizing preparing of previously unprepared rolls of material for their preparation and subsequent delivery to said roll changers of said web-fed rotary printer machine as prepared rolls of material from said depot, by positioning said unprepared rolls of material in other ones of said depot roll storage spaces, all in accordance with

said production-oriented storage strategy[[.]]; and

delivering said prepared rolls of material from said depot to said roll changers of said web-fed rotary printing machine using said material flow system.

38. (Previously Presented) The method of claim 37 further including considering criteria for a degree of use of storage in said depot in said planned production run.

39. (Previously Presented) The method of claim 37 further including considering criteria for an intended length of storage time of fresh rolls of said material during said planned production run.

40. (Previously Presented) The method of claim 39 further including determining said storage strategy including considering said criteria for an intended length of storage time of fresh rolls during said planned production run.

41. (Previously Presented) The method of claim 37 further including considering a period of an effectiveness of a glue preparation of said rolls of material during said planned production run using said implemented logic device.

42. (Previously Presented) The method of claim 37 further including providing a first shelf block remote from said web-fed rotary printing machine in said depot, providing a second shelf block adjacent said web-fed rotary printing machine and providing an inner shelf block located between said first shelf block and said second shelf block and

locating at least some of said selected ones of said roll storage spaces in said depot in said second shelf block.

43. (Previously Presented) The method of claim 42 including, in a low storage application utilizing said first shelf block for storage of only unprepared rolls, utilizing said second shelf block for storage of prepared rolls and maintaining said inner shelf block empty except for passage of said rolls.

44. (Previously Presented) The method of claim 42 including, in one of a normal storage and a high storage application, utilizing said first shelf block for storage of only unprepared rolls, utilizing said second shelf block for storage of only prepared rolls and utilizing said inner shelf block as a buffer for unprepared rolls and for prepared rolls.

45. (Previously Presented) The method of claim 37 further including considering criteria of a type of said rolls of material needed in said planned production run and further including differentiating in said type of said rolls of material needed between many small planned production runs and fewer large planned production runs.

46. (Previously Presented) The method of claim 45 further including reserving sufficient space in said depot for the return of used rolls to said depot when said planned production run includes said many small planned production runs.

47. (Previously Presented) The method of claim 45 further including storing said prepared rolls in a travel optimized manner when said production period includes said fewer large planned production runs.

48. (Previously Presented) The method of claim 37 further including determining said strategy for repositioning said prepared and unprepared rolls in said depot using criteria for a degree of storage use to be expected during said planned production run.

49. (Previously Presented) The method of claim 48 further including providing said material flow system with information regarding an actual stock of said rolls of material on hand.

50. (Previously Presented) The method of claim 49 further including determining a strategy for a production-oriented repositioning in said depot using criteria for an extent of depot occupancy during said planned production run.

51. (Previously Presented) The method of claim 50 further including providing roll changers in said web-fed rotary printing machine and considering an extent of occupancy of said depot whenever, in low occupancy, storage of said prepared rolls is taking place in a path-optimized manner with respect to one of said roll changers to be served and wherein, in high occupancy, storage of said prepared rolls is taking place chaotically in said depot acting together with active ones of said roll changers.

52. (Previously Presented) The method of claim 42 further including providing a first serving element remote from said web-fed rotary printing machine and locating said first serving element between said first and third shelf blocks, and further including providing a second serving element adjacent said web-fed rotary printing machine and locating said second serving element between said second and said inner shelf blocks.

53. (Previously Presented) The method of claim 52 further including locating ones of said prepared rolls which will be required for use within a short time in one of said second and said inner shelf blocks.

54. (Previously Presented) The method of claim 52 further including repositioning unprepared ones of said rolls of material for preparation of said rolls of materials in an access area of said second serving element.

55. (Currently Amended) The method of claim 37 further including providing [[a]] said roll preparation circuit in said depot and processing said unprepared rolls in said roll preparation circuit in said depot.

56. (Currently Amended) The method of claim 54 further including providing [[a]] said roll preparation circuit in said depot and removing unprepared rolls from one of said first shelf block and said inner shelf block, using one of said serving elements, and supplying said unprepared rolls to said roll preparation circuit.

57. (Previously Presented) The method of claim 56 further including placing said rolls of material, after passage through said roll preparation circuit, into intermediate storage in said inner shelf block.

58. (Previously Presented) The method of claim 42 further including storing said rolls of material in one of said first shelf block and said inner shelf block as a result of a storage demand from said first partial process.

59. (Previously Presented) The method of claim 42 further including delivering a prepared roll of said material from one of said first storage block and said inner storage block to a storage space in said second shelf block as a result of said first storage demand from a partial process.

60. (Previously Presented) The method of claim 50 further including categorizing a degree of occupancy of said depot below 40% as low occupancy.

61. (Previously Presented) The method of claim 50 further including categorizing a degree of occupancy of said depot above 70% as high occupancy.

62. (Previously Presented) The method of claim 38 further including storing said criteria in exact and changeable definition.

63. (Previously Presented) The method of claim 38 further including storing said criteria in a form of a changeable term of a linguistic variable of a fuzzy logic control.

64. (Previously Presented) The method of claim 37 further including providing one of a computing unit and a data processing unit in said material flow system and forwarding one of production-relevant data and use data regarding planned production from a production planning system to said one of said computing unit and said data processing unit.

65. (Previously Presented) The method of claim 64 further including determining said storage strategy and a deposit request for said unprepared rolls of material using said one of said computing unit and said data processing unit using said production-relevant data for said planned production run and information regarding an actual stock of said rolls of material, and further including fixing a time for a production preparation of said rolls of material in a preparation circuit using said implemented logic device in said material flow system and considering a limited shelf life of a glue preparation and a planned length of said production run.

66. (Previously Presented) The method of claim 64 further including directing a partial signal requesting rolls of material to said material flow system, registering said partial signal in said one of said computing unit and said data processing unit and determining said partial signal using existing data regarding depot occupancy for availability in said depot and ordering removal of said prepared and unprepared rolls of material from said



depot in response to said request directly through said material flow system.

69. (Previously Presented) The method of claim 37 further including continuously checking an occupancy of said depot in respect to planned requirements using a predetermined criteria.

70. (Canceled)